



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB877212-08-21
Job Sheet 192395



Part No: RB877212-08-21

Job Qty: 2 pcs

Part Name: Cap, Ø2 x 1-3/8



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154	2 pcs	5/3/19	5/3/19	0.00	0.13	SL-154	25w-1	DAS 5 9-89
110	QC 2	2 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1	DAS 45 9-89	
							QC 2 - 12	45	
							QC 2 - 14	9-89	
							QC 2 - 17	19-03-29	
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S170101



Part: RB877212-08-21

Job No: 192395

Serial No/Batch: S170101

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/05/19

120 QC 8	2 pcs	5/3/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
125 Outsource - 4 - Anodize	2 pcs	5/3/19		GRO002-VC	
126 Packaging 2-1 - Receive - B4B	2 pcs 6 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
127 QC 6	2 pcs	5/3/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
130 Packaging 3-1 - Stock - B4B	2 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	2 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Machine as per folio FC 734 FOLIO REV: AA DWG REV: D 2-Deburr
 Descriptions: 120 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 125 - Issue P/O; _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -
 Material type; 6061T6 -Certificate of Conformity is required
 126 - C of C required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R2.250	6061-T6 Round Bar 2.250"	.2580 ft (129 ea)	100-SL-154	5119601

45

9-89

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M6061T6R2.250	0	6	0
Part Specifications				
Specifications could not be found.				

Plex 3/22/19 10:35 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

8

7

6

5

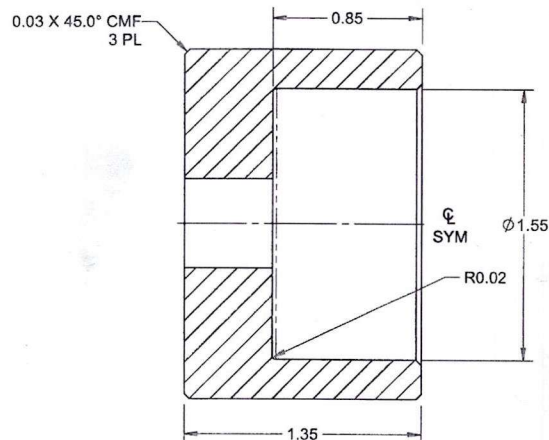
4

3

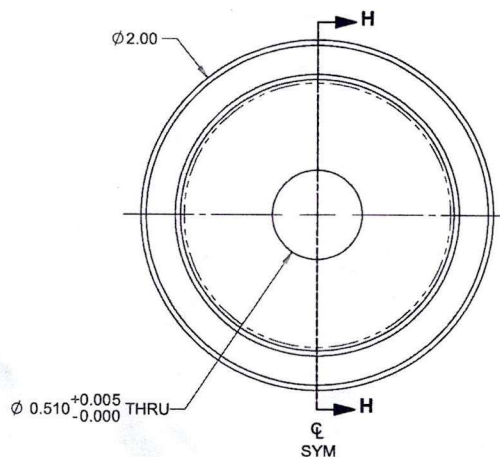
2

1

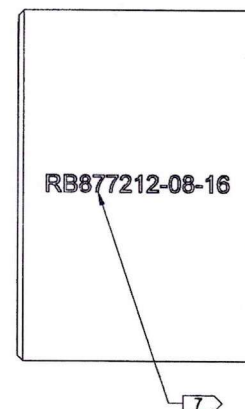
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192395 M15
19-03-22



SECTION H-H



RB877212-08-21 CAP



RB877212-08-16

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 9 OF 11
APPROVED	VP	TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
DATE	3/21/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043150



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043150

PO Date: 4/9/19

Due Date: 4/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189386	C45-2-1	Sideplate - MRK Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed - X3	-	4/15/19	3 pcs	0 pcs	3 pcs	\$6.00/pcs	\$18.00

APR 15 2019

DP

Line Item Note *** RUSH - RUSH - RUSH ***
PLEASE DELIVER ASAP

2	192209	C45-9-1	Clock Spring Cover -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed - X17	-	4/15/19	17 pcs	0 pcs	17 pcs	\$6.00/pcs	\$102.00
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APR 15 2019

DP

Line Item Note *** NEED BACK APRIL 18,2019 ***



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PURCHASE ORDER

PO043150



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190534	RBW109-3130-34-1-3	Rod, Ø2-5/8 X 11-1/2 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X4	-	4/15/19	4 pcs	0 pcs	4 pcs	\$30.00/pcs	\$120.00
APR 15 2019 DP											
Line Item Note *** NEED BACK APRIL 18,2019 ***											
4	192395	RB877212-08-21	Cap, Ø2 x 1-3/8 -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X6	-	4/15/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
APR 15 2019 DP											
Line Item Note *** NEED BACK APRIL 18,2019 ***											

DAS
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Canada

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PURCHASE ORDER

PO043150



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	190616	20NR-10	Spacer (note: please use the BLUE ones with 8NR and the GOLD ones with 20NR) (Outsource process-Anodize per QSI017 4.1.10.1)-Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR GOLD, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed X1	-	4/15/19 APR 15 2019	1 pcs	0 pcs DP	1 pcs	\$12.00/pcs	\$12.00
Line Item Note *** NEED BACK APRIL 18,2019 ***											
	191265			Firmed	-	4/15/19	9 pcs	0 pcs	9 pcs	\$12.00/pcs	\$108.00
Sub Total:							10	0	10		\$120.00
										Grand Total:	\$480.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/10/19 8:40 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



0 1 8 3 6 3 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018363- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.					
11-Apr-2019		SVETLANA DORZHIYEVA				043150				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order		
1	C45-2-1 Rev.	C45-2-1 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	3	3	0	0	0		
2	C45-9-1 Rev.	C45-9-1 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	17	17	0	0	0		
3	RBW109-3130-34-1-3 Rev.	RBW109-3130-34-1-3 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4	0	0	0		
4	RB877212-08-21 Rev.	RB877212-08-21 01 -ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	6	6	0	0	0		
5	20NR-10 Rev.	20NR-10 01 -ANO-GOLD [ANODIZE GOLD] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	1	1	0	0	0		
6	20NR-10 Rev.	20NR-10 01 -ANO-GOLD [ANODIZE GOLD] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	9	9	0	0	0		

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.